

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-004036**Date Inspected:** 10-Sep-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 1400**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG**Summary of Items Observed:**

Tower Shop Bay 3 Deck Panel repairs

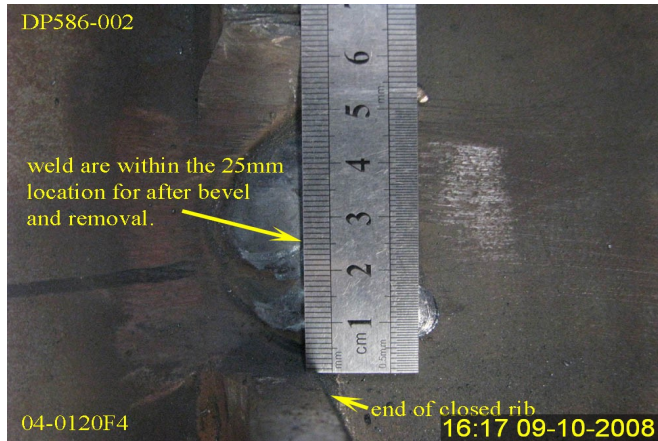
The QA Inspector randomly observed ZPMC personnel performing grinding of repairs for the Orthotropic Box Girder (OBG) deck panel Partial Joint Penetration (PJP) welds. During initial observations it was noted that fourteen (14 ea) deck panels are inside the shop. This QA inspector was informed by ZPMC MT technician that during his MT inspection on deck panel DP586-002 and had found cracks in the base metal at the ends of welds 008/009. This QA inspector observed ZPMC repair these welds without engineer's approval and no documentation of welding parameters. ZPMC QC Fu Yu Hong was informed that an incident report [TL-15] will be issued for this occurrence. This QA inspector while continuing his observation noted that ZPMC was continuing to perform deck panel weld repairs without documenting the welding parameters on DP567-001. ZPMC QC Fu Yu Hong was informed that an incident report will be issued for this occurrence also. A 3 party final visual inspection was conducted by ZPMC, ABF and Caltrans QA inspector for deck panel DP567-001 after all 3 parties had agreed the repairs appeared to be within compliance at the time of VT the ABF tracking tag was signed by all parties involved. Deck panel DP586-002 was requested for final VT by ZPMC and it was relayed to ABF Kevin Chen that CT would participate with the VT but due to a pending TL-15 could not sign the panel as within compliance at this time. ABF Kevin Chen proceeded with his final VT of the deck panel and discovered multiple locations on the first weld that was not in compliance. Mr. Chen then spoke with ZPMC and informed them that ZPMC needed to go back through the repair areas again that this panel was not ready for a final visual inspection by ABF or CT. Certified Welding Inspector for ZPMC Li Yan Hua was present at this location along with QC Fu Yu Hong and told this QA inspector that they would go back through the deck panel to insure it was ready for final VT at a later time.

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# WELDING INSPECTION REPORT

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## Summary of Conversations:

As stated above.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Ady Velasco , 1-381-694-2685, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Riley, Ken	Quality Assurance Inspector
<b>Reviewed By:</b>	Carreon, Albert	QA Reviewer

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